

Work Order ID 152487

152487

Page 1

Tuesday, October 25, 2016 9:28:26 AM

Item ID: D4883-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: End Fitting
 Start Date: 10/25/2016 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 11/3/2016 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: em Date: 10/10/25 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4883	C								
100	DOOSAN LATHE	0.00							DAS 45 16-10-27 9-89
100									
Doosan	Memo	0.55							
Doosan Lathe	1- Turn as per Dwg. D4883-5 Turning Detail & Folio FB254. 2- USE DT10005 For sizing blanks.								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 45 16-10-23 9-89
110									
QC	Memo	0.02							
Quality Control									
120	HAAS CNC VERTICAL MACHINING #1	0.11							DAS 33 9-89
120									
HAAS 1	Memo	0.77							16/10/31
HAAS CNC vertical machine #1	1-Machine as per Folio Fb254 & Dwg D4883-5 END FITTING. deburr and Break all sharp edges.								

P.T.O.

DQA:

Date:

2017-02-22

QA Closed

Date:

JAN - 9 2017

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: <u>152487</u> Part No. <u>D4883-5</u> NCR No. <u>17-10208</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date: <u>16/10/31</u>		Step #: <u>130</u>		QTY Effective: <u>3</u>			MRB (QSI042) Approval DAS 9 9-89 <u>16-11-01</u>		
Description Work Order Deviation				Disposition				Completed By DAS 33 9-89 <u>16-11-01</u> Lead hand / Supervisor Approval Verification <u>16/10/31</u> QC / QA Coordinator DAS Approval 9 9-89 <u>16-11-01</u>	
$\varnothing 0.670$ is off center with $\varnothing 0.250$, also dimension 0.080 and 0.030! RC $\rightarrow$ wear off roughing tool Move set-up dig				scrap, no replace Modifi process of Machining Slowed Down Feed in Prog. <u>16-11-01</u>					
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☒ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☒ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☒ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		OTHER :							

Work Order ID 152487

152487

Page 3

Tuesday, October 25, 2016 9:28:26 AM

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo Certificate of conformity is req'd.	0.00 0.03				12x.	DAS 26 9-89		NOV 02 2016
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.03				(12)	DAS 30 9-89		NOV 02 2016
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>St134</u> Memo	0.00 0.02				12	DAS 6 9-89		NOV 03 2016

Work Order ID 152487

Tuesday, October 25, 2016 9:28:26 AM

152487

Page 4

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.17							
Quality Control									

DAS
21
9-29

NOV 03 2016

Picklist Print

Tuesday, October 25, 2016 9:28:26 AM

Page 1

Work Order ID: 152487

152487

Parent Item: D4883-5

D4883-5

Parent Item Name: End Fitting

Start Date: 10/25/2016

Required Date: 11/3/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV A RQ VERIFIED BY DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R2.000		Purchased			No	100	f	32.0000	0.236	2.484211			

M174PH-H900R2 000

17-4SS H900 ROUND BAR 2.000

Location

Loc Qty

Loc Code

MAT031

32

M128314

17

M128809

12

M129892

3

4.9#

DAS

45

9-89

16-10-27

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO30004	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PC34132
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT (LIQUID PENETRANT CRACK TEST) ON THE FOLLOWING TWENTY ONE (21) END FITTINGS AND ON THE FOLLOWING NINE (9) STRUTS:

ITEMS ID# D4883-5 END FITTINGS WORK ORDER# 152487 (12 ea)
ITEMS ID# D4883-3 END FITTINGS WORK ORDER# 152525 (09 ea)

ITEMS ID# D4880-1 STRUTS WORK ORDER# 152535 (09 ea)

DAS
26
9-89

NOV 02 2016

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE AS PER ASTM1417 M-13						2 NOV 2016	
NO CRACK FOUND							
PEN.(ZL-56, MPO13600), DEV.(SKD-S2, MPO11715), CLEANER(SKC-S, MPO							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date: 2 NOV 2016
Name: CHRISTIAN BRIEN		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34132**

Purchase Order Date 11/1/2016

PO Print Date 11/2/2016

Page Number 2 of 4

Order From :
SKYSERVICE
6120 MID. LILL ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 905-678-5636

Ship To Company

Ship To Phone

Ship Via:

Delivered

Ship Acct:

3 152487

D4883-5 END FITTING

11/2/2016

Yes

11/2/2016

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

12.00

\$12.31

\$147.72

DAS
26
9-89

NOV 02 2016

Line Total:

\$147.72

4 152435

D4880-1 STRUT

11/2/2016

Yes

11/2/2016

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

9.00

\$14.41

\$129.71

Line Total:

\$129.71

5 148169

D412-664-203
CROSSTUBE

11/2/2016

Yes

11/2/2016

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

1.00

\$147.72

\$147.72

Line Total:

\$147.72

Note:

11/2/2016